

Date: Friday, 5/25/2007 8:37:04 AM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---------------------------------------|----------------|------------------|---|----------|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : 205 SKIDTUBE "I" BEAM | |
| Job Number | : 32652 | | Part Number | : D2596 | |
| Estimate Number | : 10346 | | Drawing Number | : D2596 REV C | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 5/25/2007 | S.O. No. : N/A | Drawing Revision | : C | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : N/A | | Due Date | : 6/15/2007 | |
| Previous Run | : 32218 | | Qty: | 8 | Um: Each |
| Written By | : | | Comment | : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D | |
| Checked & Approved By | : | | M | | |
| Comment | : M | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|---|
| 1.0 | D25003100 | Ext'n - 'I' Beam Web 4" |
| | |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) - Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion B 25751 2 B 31223 | | |
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
| | |  |
| Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr | | |
| 3.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| | |  |
| Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI_005 4.1 | | |
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| | |  |
| Comment: INSPECT WORK TO CURRENT STEP <i>RE/PW 07-6-15</i> | | |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | |  |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: L6 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/06/15
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:37:04 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 32652

Part Number: D2596

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



07.26.15 (H)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



a 07.26.15

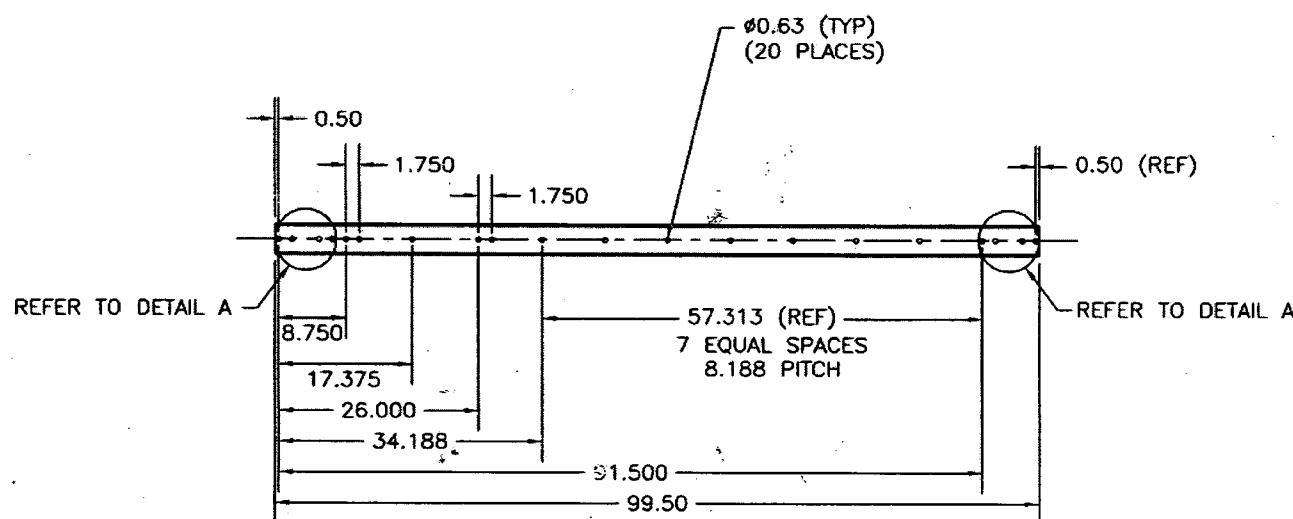
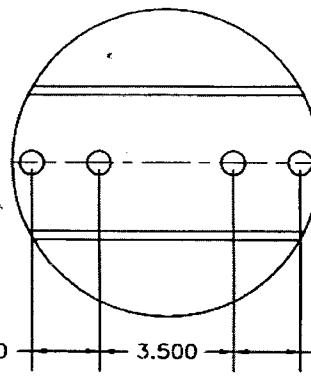
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
98.09.17 DS

DART

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| | | | | |
|----------------------|-----------------------|---|---------------|--------------|
| DESIGN <i>MM</i> | DRAWN BY <i>JP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>MM</i> | APPROVED <i>JP</i> | DRAWING NO. D2596 | REV. C | SHEET 1 OF 1 |
| DATE 98.09.14 | DATE 96.09.16 | TITLE 205 WEB | SCALE 1:24 | |
| | DATE 97.07.23 | NOTE Ø0.63 HOLE WAS Ø0.56 | | |
| C | 98.09.14 | INCORPORATED DEO 9097 | | |